

Date: Friday, 5/25/2007 8:37:26 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ASSEMBLY
Job Number : 32657	
Estimate Number : 10464	
P.O. Number : <i>N/A</i>	Part Number : D3278041
This Issue : 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3278 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 31838	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/15/2007 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est:A 04.04.19 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	32657A	SUPPORT
-----	--------	---------



Comment: Sub-Component SUPPORT

D3278-1 B *31661 7X - B31838 30X - B31735 3X*

2.0	32657B	SUPPORT
-----	--------	---------



Comment: Sub-Component SUPPORT

D3278-2 B *B31661 -*

3.0	D32783	Spacer
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Spacer

Pick:

Qty Part Number

1 D3278-3

Description

Spacer

Batch

*31941 11X**B 32692 x28*

4.0	MS20426AD37	RIVET
-----	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

RIVET

Pick:

Qty Part Number

4 MS20426AD37

Description

Rivet

Batch

*172694 16527**80706-11**107/06/11*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Rivet spacers with support as per Dwg D3278.

*ml07/06/11**x40*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:37:26 AM  
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## Process Sheet

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Drawing Name: SUPPORT ASSEMBLY

Job Number: 32657

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/11

40

7.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1

Description

Mounting Lug

Batch

B30992

8.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A

Description

Bolt

Batch

M10401C 50 X M104106

9.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416

Description

Washer

Batch

M103691-

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

2 MS21042L4

Description

Nut

Batch

102552

Per 6/11

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

\*\*\*DO NOT TIGHTEN BOLTS\*\*\*

Identify as D3278-041

x40  
ml 07/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 2 Date: 07/06/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:37:26 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 32657

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/14

(40)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 471

SP

07/06/14 (40)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/14

Job Completion



u 07/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

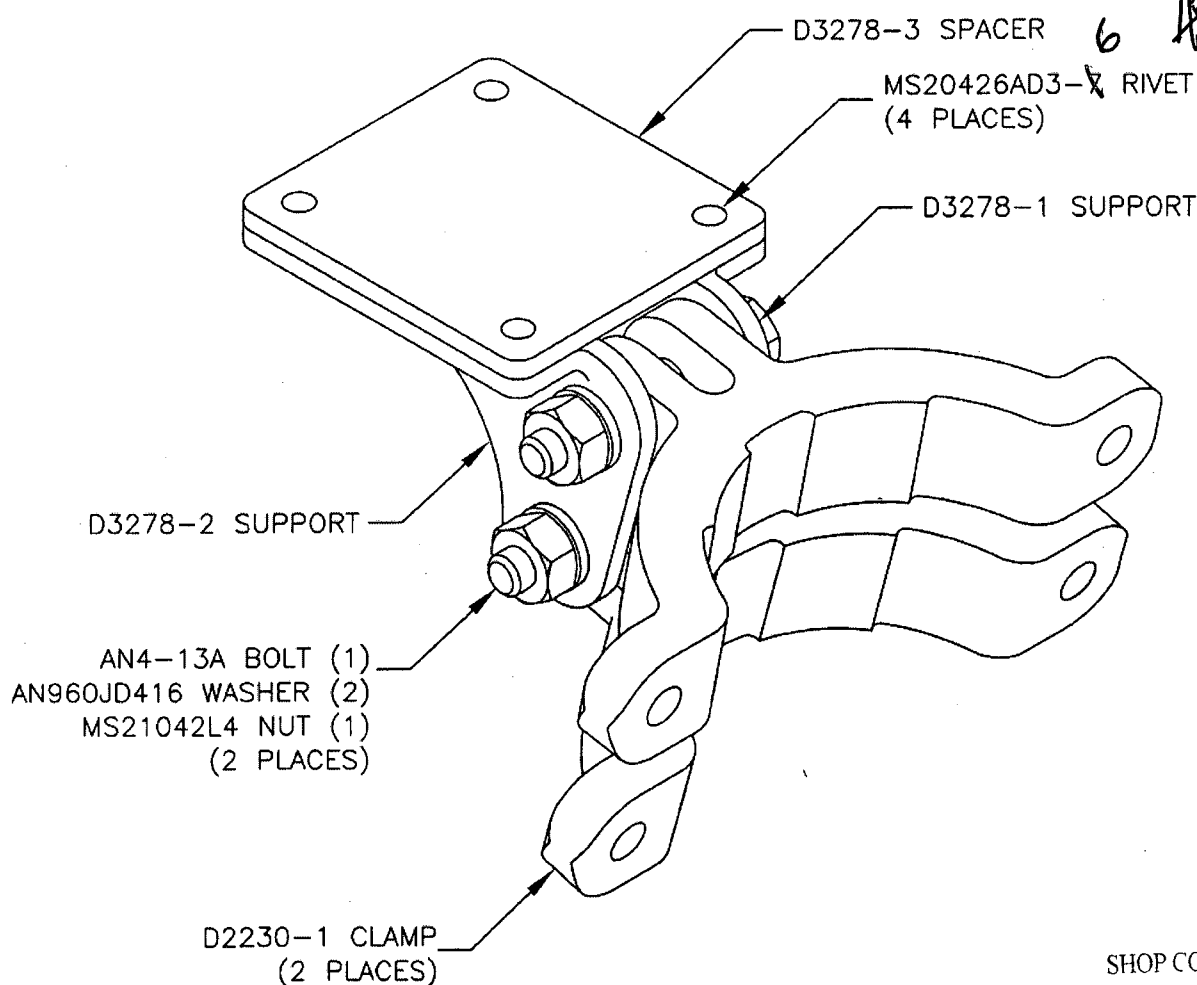
NOTE: Date & initial all entries



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DATE	05.03.31			TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03			NEW ISSUE	
B	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED  
05.04.04 *[Signature]*

## D3278-041 SUPPORT ASSEMBLY



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NO. 32657

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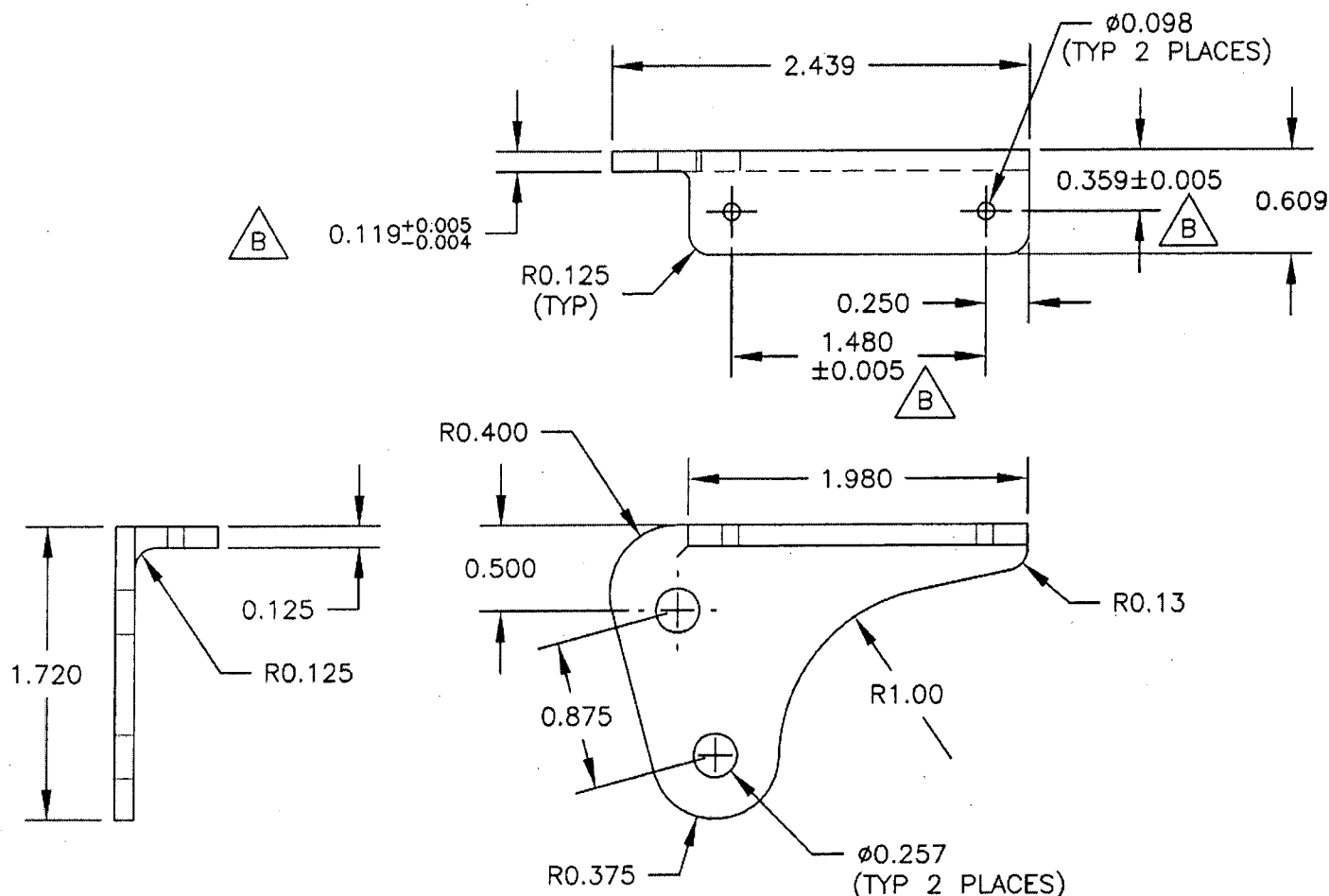
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED

05.04.04 *[Signature]*



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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250/11

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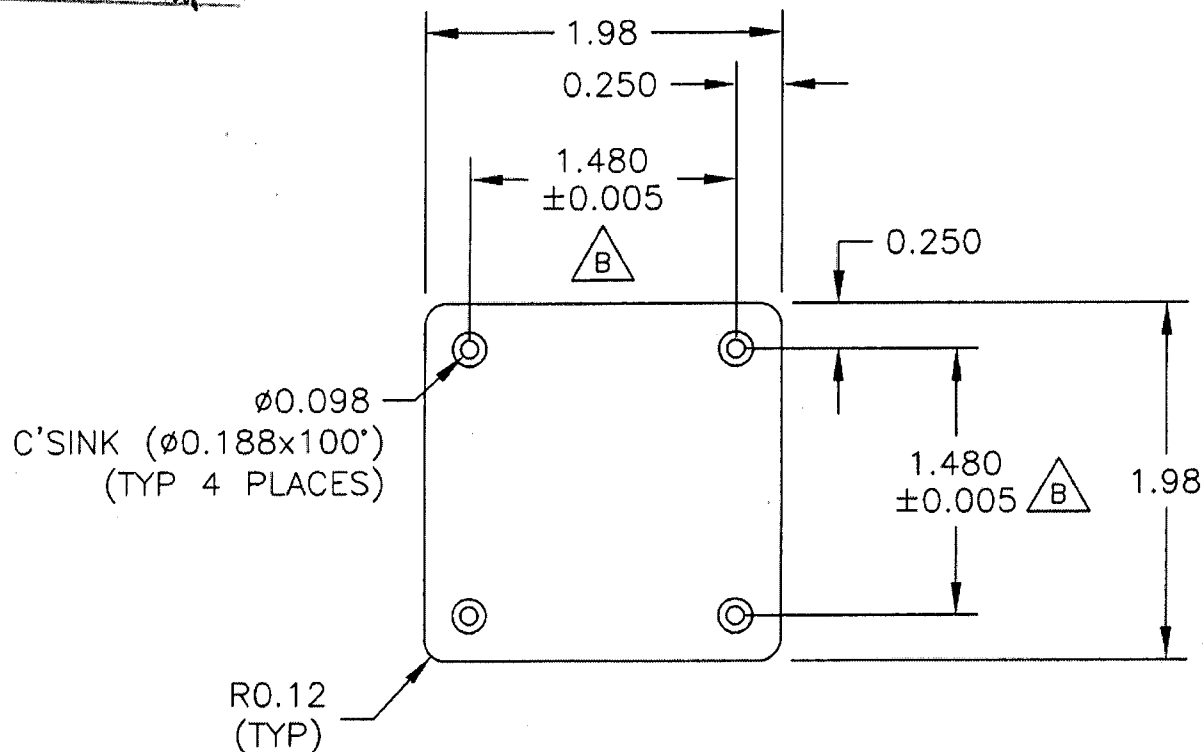




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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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